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Mazdoor Kisan Shakti Sangathan

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**“पुराने को छोड़ नये के तरफ”**

Jawaharlal Nehru

**“Step Out From the Old to the New”**

IS 7511-4 (1986): Dimensions For Neck Finishes, Part 4:  
Roll-on sealed threads pilfer-proof [CHD 10: Glassware]

**“ज्ञान से एक नये भारत का निर्माण”**

Satyanaaranay Gangaram Pitroda

**Invent a New India Using Knowledge**



**“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”**

Bhartṛhari—Nītiśatakam

**“Knowledge is such a treasure which cannot be stolen”**





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*Indian Standard*

## DIMENSIONS FOR NECK FINISHES

### PART 4 ROLL-ON THREADS PILFERPROOF

*(First Revision)*

**1. Scope** — Specifies dimensions for roll-on threads pilferproof ( ROSPP ).

**2. Types** — The roll-on threads pilferproof shall be of the following types:

- a) Standard finish,
- b) Shallow finish,
- c) Deep finish, and
- d) Extra deep finish.

#### 3. Dimensions

**3.1** The dimensions of the roll-on threads pilferproof shall be as given in Table 1.

**3.2 Sealing Surfaces** — The sealing surface shall remain flat to a minimum of 0.9 mm and in addition shall conform to the dimensions given in Table 1. The surface shall be as regular and smooth as possible.

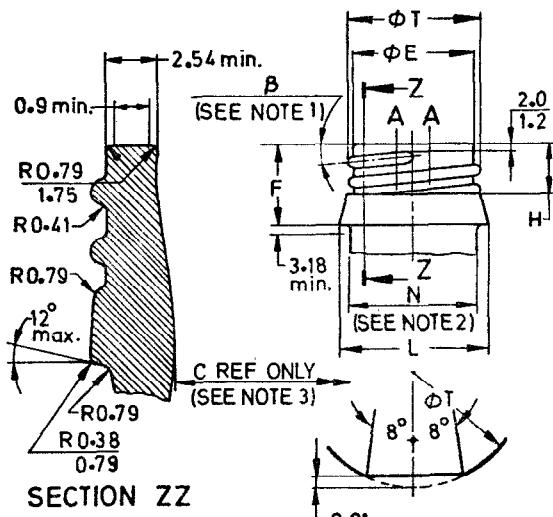
#### 4. Checking and Inspection

**4.1** All essential dimensions may be ascertained by appropriate method of measurement. They may also be checked with suitable gauges.

TABLE 1 DIMENSIONS OF ROLL-ON THREAD PILFERPROOF (ROSPP)

( Clauses 3.1 and 3.2 )

All dimensions in millimetres.

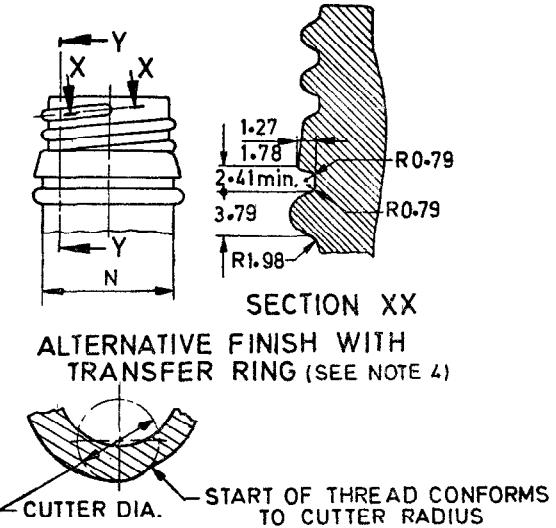


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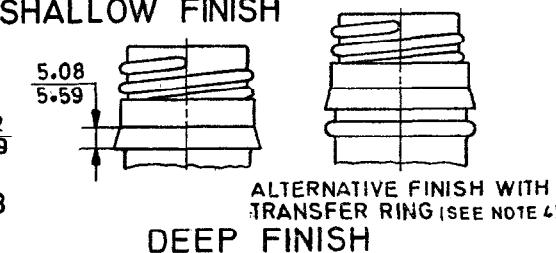
#### **STANDARD AND SHALLOW FINISH**



## THREAD CROSS SECTIONS



DEEP FINISH



No. or Size	T		E		H		F		L		N	Angle $\beta$	Thread Cutter Dia	Pitch
	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max			
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)	(13)	(14)	(15)
STANDARD FINISH														
22	21.69	21.19	19.56	19.06	8.51	8.13	12.96	12.58	22.20	21.70	19.05	2°50'	9.53	3.17
25	24.66	24.16	22.52	22.03	8.51	8.13	14.28	13.90	25.17	24.67	22.10	2°29'	9.53	3.17
28	27.41	26.77	25.17	24.53	9.60	9.10	15.67	15.17	28.04	27.40	24.89	2°33'	12.70	3.63
31.5	30.53	29.90	28.30	27.66	9.60	9.10	15.67	15.17	31.17	30.55	27.94	2°16'	12.70	3.63
53	52.50	51.50	50.27	49.27	9.60	9.10	15.67	15.17	53.39	52.39	49.78	1°18'	12.70	3.63
70	69.50	68.50	67.11	66.11	10.10	9.60	14.87	14.49	70.13	69.37	66.78	1°18'	12.70	4.23
SHALLOW FINISH														
38	37.49	36.73	35.36	34.60	8.71	8.33	13.72	13.22	38.13	37.37	34.80	1°36'	12.70	3.17
46	45.14	44.38	43.00	42.24	9.71	8.33	13.72	13.22	45.77	45.01	42.42	1°20'	12.70	3.17
DEEP FINISH														
31.5	30.53	29.89	28.30	27.66	9.60	9.10	21.64	21.14	31.17	30.53	27.94	2°16'	12.70	3.63
EXTRA DEEP FINISH														
30	28.63	27.99	26.49	25.86	8.71	8.33	32.20	31.70	29.26	28.62	26.11	2°4'	12.70	3.17

Note 1 —  $\beta$  = Helix angle or angle of fixture to cutter; and  $\tan \beta = \frac{\text{Pitch}}{\pi (\text{Mean between mean } A \text{ and mean } D)}$

Note 2 — Maintain the N dimension for a depth of 3.18 mm minimum.

Note 3 — C dimensions is intended for filling tube clearance and should be confirmed with the glass manufacturer.

Note 4 — The choice of any alternative finish involving a transfer ring should be confirmed with the glass manufacturer.

Note 5 — The Max and Min T, E, L, F and N may be determined by the use of suitable gauges.

## EXPLANATORY NOTE

A variety of glass finishes are now being produced by the glass containers industry. Most of these finishes are being used by packers who have facilities for high speed filling and capping operations. Consequently it has become necessary to standardize upon the dimensions of different types of glass finishes.

This standard was first issued in 1974 titled 'Summary sheet on glass containers neck finishes'. As the standard mainly lays down the dimensions for various types of neck finishes for glass containers, the standard has been retitled as 'Dimensions for neck finishes'. Since its first issue, it was observed that a number of sizes recommended under the shallow continuous thread finish range were not in use. On the contrary, a number of sizes, not included in earlier issue were very popular with the industry. Also glass neck finishes not included in the first version were popular with the trade. In view of this, the revision of the standard became necessary.

The following are some of the changes made in this revision:

- a) The sizes of various neck finishes not in use were deleted and the additional sizes included.
- b) A new glass finish range namely, shallow continuous deep thread finish, has been included.
- c) Certain individual dimensions of glass neck finishes have been revised in view of the limitations posed by the glass container manufacturing processes.
- d) Vacuum lug finishes which have recently become very popular with wide mouth glass containers have also been included. These finishes are non-pilferproof.
- e) The notations representing different glass finish dimensions have been changed to be in conformity with internationally accepted practices.
- f) Tall continuous neck finish has been deleted as the same is no longer popular.

This standard is being issued in the following parts:

Part 1 Shallow continuous thread finish ( R3 );

Part 2 Shallow continuous thread finish for deep screw caps ( R3/D );

Part 3 Roll-on threads non-pilferproof ( RONPP );

Part 4 Roll-on threads pilferproof ( ROSPP );

Part 5 Vial goldie seal glass finishes;

Part 6 Dual neck finish;

Part 7 Crown finish; and

Part 8 Vacuum lug finish.

While preparing this standard, assistance has been derived from the following:

ISO 8162-1985 Glass containers — Tall crown finishes — Dimensions, issued by International Organization for Standardization ( ISO );

ISO 8163-1985 Glass containers — Shallow crown finishes — Dimensions, issued by International Organization for Standardization ( ISO );

ISO/DP 9100 Glass containers — Vacuum lug finishes for wide mouth container — Dimensions, issued by International Organization for Standardization ( ISO );

BS 1918 : Part 1-1978 Glass container finishes: Part 1 Specification for continuous thread finish, issued by British Standards Institution ( BSI ); and

BS 1918 : Part 2-1981 Glass container finishes: Part 2 Specification for crown finish, issued by British Standards Institution ( BSI ).

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TO

IS:7511(Part 4)-1986 DIMENSIONS FOR NECK FINISHES

PART 4 ROLL-ON THREADS PILFERPROOF

(First Revision)

(Page 3, Table 1, col 6, row 8) - Substitute  
'8.71' for '9.71'.

(MCPD 13)      Reprography Unit, BIS, New Delhi, India